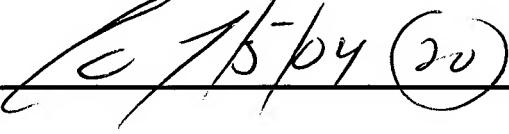


Date: Monday, 4/23/2007 1:52:49 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET	
Job Number	: 31997				
Estimate Number	: 12713				
P.O. Number	: N/A		Part Number	: D353641	
This Issue	: 4/23/2007 S.O. No. : N/A		Drawing Number	: D3536 REV A	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 4/30/2007 Qty: 20 Um: Each	
Checked & Approved By					
Comment	: Est Rev:A		New Issue 07-02-14 JLM		
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	MNEO60S063	NEOPRENE SHEET 0.063			
					
Comment: Qty.: 0.7144 sf(s)/Unit Total : 14.2884 sf(s) NEOPRENE SHEET 0.063 Batch: M103/04					
		SAP	07/05/03		20
2.0	WATER JET	FLOW WATER JET			
					
Comment: FLOW WATER JET 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A					
		SAP	07/05/03		20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
					
Comment: INSPECT PARTS AS THEY COME OFF MACHINE					
		SAP	07/05/03		20
4.0	QC8	SECOND CHECK			
					
Comment: SECOND CHECK					
		BC	07-05-04		20
5.0	PACKAGING 1	PACKAGING RESOURCE #1			
					
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PR1544C					
					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3536-841 PAR #: _____ Fault Category: Prod / Engineered ^{Card not} NCR: Yes No DQA: Q Date: 07/05/07
 QA: N/C Closed: Q Date: 07/05/07

NCR: <u>31997</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/05/07</u>	<u>2.0</u>	<u>Welding</u>						
<u>07/05/07</u>	<u>2.0</u>	Dimensions were not correct Dxf with error. It had the remainder of the material for the wearplate Joggle.	<u>QS1042</u>	Scrap - destroy - replace Dxf corrected.	<u>QS1042</u> <u>07/05/07</u>	<u>QS1042</u> <u>07/05/07</u>	<u>QS1042</u>	<u>QS1042</u> <u>07/05/07</u>

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 31997

Part Number: D353641

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(qd)

Comment: FINAL INSPECTION/W/O RELEASE

17.05.08

Job Completion



il 07.05.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

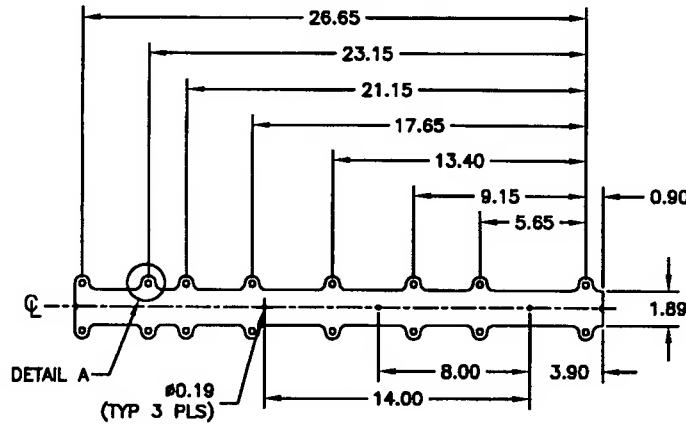
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

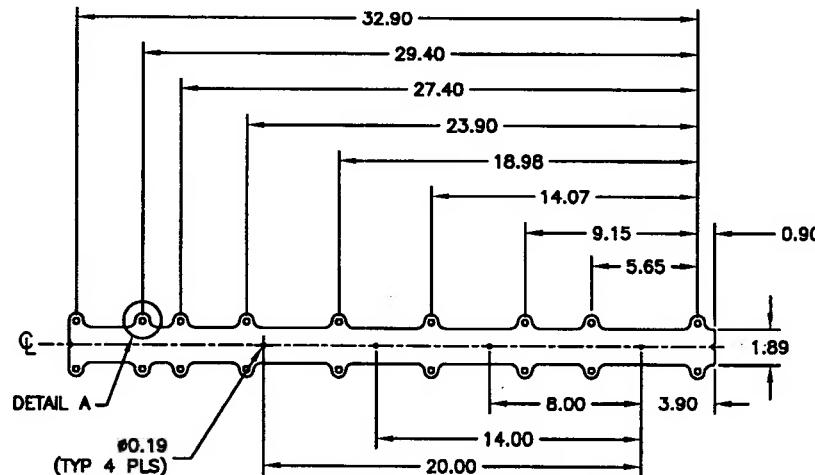
D3536-11 GASKET

**D3536-11 GASKET**

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WITHOUT NOTICE
WORK ORDER
NO. 31897

NOTES

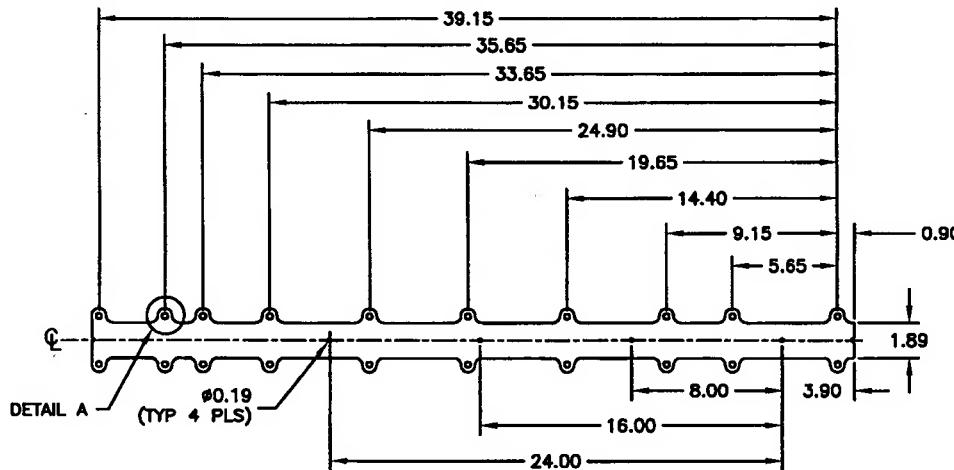
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

**D3536-13 GASKET**

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 1 OF 6 SCALE 1:10
A	06.10.25	NEW ISSUE

DART

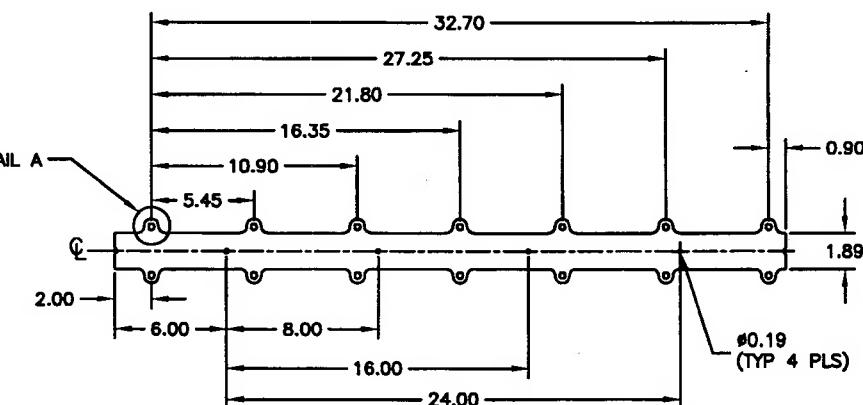
07.02.12

**D3536-15 GASKET**

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WORK ORDER
NO. 3198

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

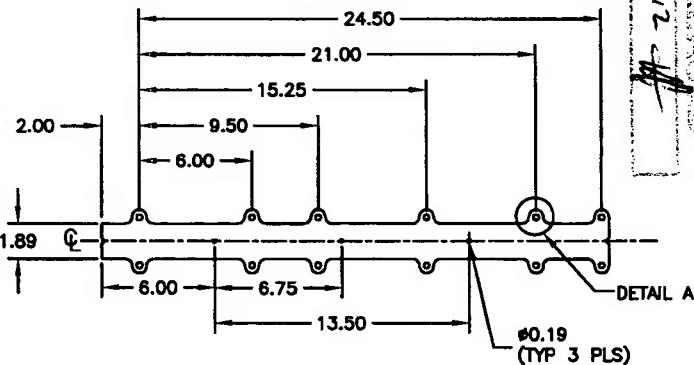
**D3536-21 GASKET**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	C.B	PORT HADLOCK, WA
checked PH	Approved PH	DRAWING NO.
06.10.25		D3536
		TITLE
		GASKET
		SCALE
		1:10
		REV. A
		SHEET 2 OF 6

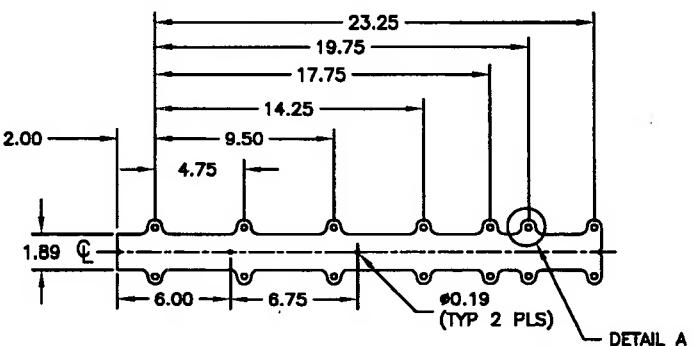
DART

DESIGN C.B	DRAWN BY C.B	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25		SCALE 1:10

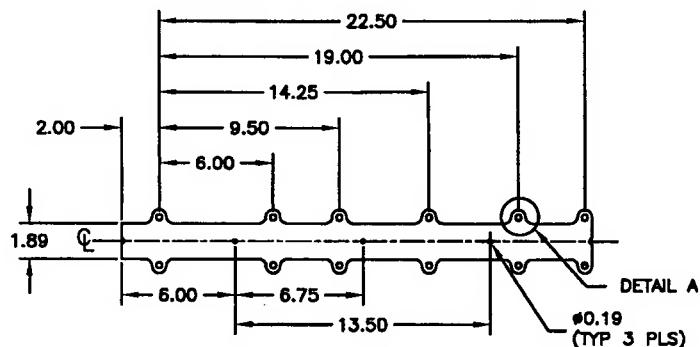
RELEASER
07.02.12



D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

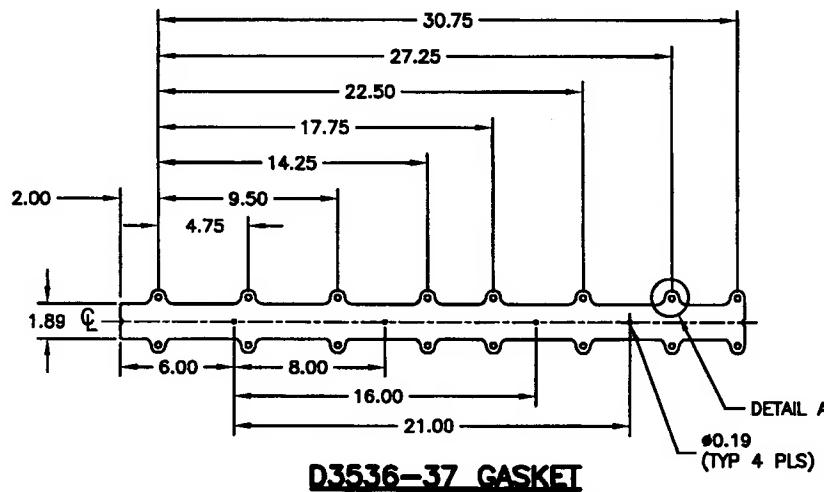
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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WORK ORDER
NO. 31947

DART

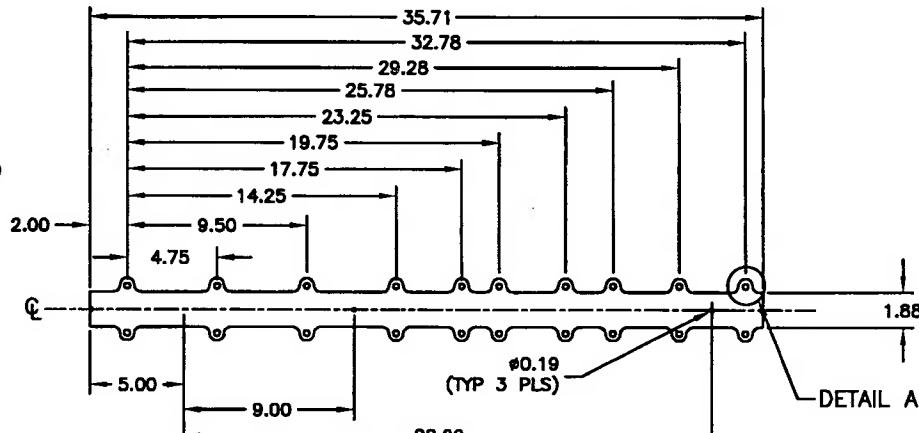
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 5 OF 6 SCALE 1:10

07.02.02
[Signature]

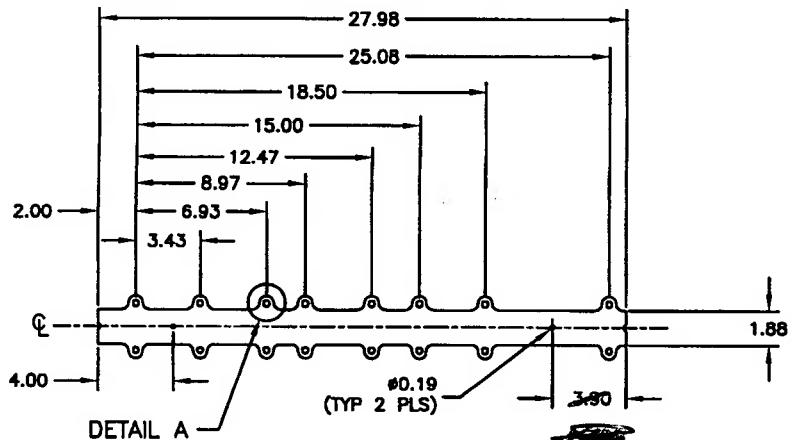


NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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WORK ORDER
NO. **312817**



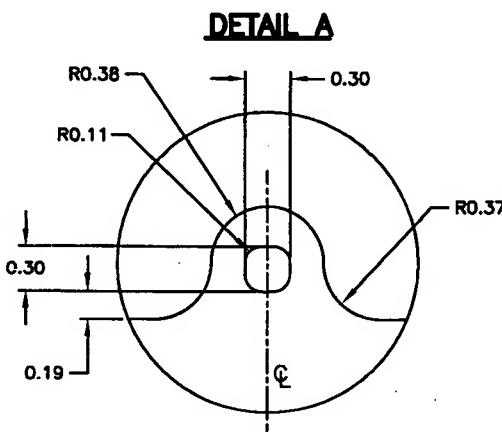
D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 31997



DETAIL A

DRAWN BY C.B		DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED PH	APPROVED HF	DRAWING NO.	REV. A
		D3536	SHEET 6 OF 6
DATE	TITLE	SCALE	1:10
06.10.25	GASKET		

DART AEROSPACE LTD

Work Order: 31997

Description: GASKET

Part Number: D3536 - 41

Inspection Dwg: D3536 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 27.98	+/- 0.030	28.00	✓		Vern/HMT	
B 25.08	+/- 0.030	25.08	✓		H-T/Vern	
C 18.50	+/- 0.030	18.50	✓		H-T	
D 15.00	+/- 0.030	15.00	✓		H-T	
E 12.47	+/- 0.030	12.480	✓		H-T Vern	
F 8.97	+/- 0.030	8.98	✓		H-T/Vern	
G 6.93	+/- 0.030	6.93	✓		Vern	
H 3.43	+/- 0.030	3.43	✓		Vern	
I 2.00	+/- 0.030	2.00	✓		Vern	
J 4.00	+/- 0.030	4.01	✓		Vern	
K Ø 0.19	+/- 0.030	Ø 0.19	✓		Vern	
L 1.88	+/- 0.030	1.90	✓		Vern	
M 0.30	+/- 0.030	0.30	✓		Vern	
N 0.30	+/- 0.030	0.30	✓		Vern	
O 0.063	+/- 0.010	0.060	✓		Vern	
P 5.00	+/- 0.030		AAT		Vern	
Q 3.90	+/- 0.030	3.890	✓		Vern	
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAY
Date:	07/05/04

Audited by:	
Date:	07.05.04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

